

Date: Tuesday, 10/06/2008 12:54:35 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: OUTER FWD SADDLE		
Job Number	: 39793			Part Number	: D5951		
Estimate Number	: 11076			Drawing Number	: D5951 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 30/06/2008 Qty: 12		
Previous Run	: 39603				Um: Each		
Written By	:						
Checked & Approved By	: <u>JUL 08 10.10</u>						
Comment	: Est Rev:E Re-Format 05-11-29 JLM						
	: Est Rev:E Re-Format 05-11-29 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101013	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) <i>* no estimate in the computer</i> D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: <i>B40 350</i>	
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5951, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble	
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		<i>88 fmk 08/08/04</i>	
		Comment: INSPECT ALL DIM TO DIM SHEET	
4.0	QC8	SECOND CHECK	
		<i>08/08/04</i>	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<i>10/08/04</i>	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	
		<i>10/08/04</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DS951 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 39793		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/03	2	1 part, the hole for the skid bolt was off of .020" 1 part, the hole for the skid bolt was off of .015" R.C. the hole for the flange was too big for the dowel pin in the last operation. Dowel pin was worn out.	/	Parts acceptable per Test & Fit ASS'Y Replace all dowel pins.	08/08/03	/	/	/
			DS1W2			08/08/04	DS1W2	08/08/04

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 39793

Part Number: D5951

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M 108523



(MF)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1-20

START TIME:

08-08-18

OVEN TEMPERATURE:

328

FINISH TIME:

1-30

m/l 08/08/18

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-18

(MF)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST491

AS 08/08/19 X(4)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/20 X(4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39793
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		.444	.440	.440	.440		
B	1.745	1.755		1.754	1.750	1.750	1.750		
C	5.245	5.255		5.248	5.250	5.248	5.249		
D	6.995	7.005		7.002	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.252	5.256	5.250		
F	4.745	4.755		4.748	4.750	4.750	4.751		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.527	1.525	1.526		
I	3.048	3.058		3.055	3.056	3.054	3.054		
J	4.575	4.585		4.579	4.578	4.577	4.580		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.501	.500	.502	.502		
N	1.615	1.635		1.628	1.632	1.626	1.632		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.257	2.258	2.255	2.255		
Q	0.307	0.312		.310	.310	.309	.309		
R	0.760	0.765		.760	.760	.761	.761		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.380	1.384	1.380	1.385		
U	2.000	2.020		2.000	2.003	2.001	2.006		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>cmf</i>	Audited by:	<i>J.L.</i>
Date:	08/08/03	Date:	08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>ds</i>

DART AEROSPACE LTD	Work Order:	39793
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X5	X6	X7	X8	By	Date
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.248	5.248	5.248		
F	4.745	4.755		4.751	4.751	4.750	4.750		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.054	3.057	3.055	3.054		
J	4.575	4.585		4.581	4.578	4.578	4.578		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.503	.503	.502		
N	1.615	1.635		1.633	1.634	1.633	1.633		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.258	2.258	2.258	2.258		
Q	0.307	0.312		.309	.309	.310	.309		
R	0.760	0.765		.760	.760	.761	.766		
S	0.490	0.510		.501	.500	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.006	2.006	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>cm</i>	Audited by:	<i>J.L</i>
Date:	08/08/04	Date:	08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD <i>CF</i>	<i>DS</i>

DART AEROSPACE LTD	Work Order:	39793
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1"	2"	3"	4"	By	Date
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.526	1.526	1.526		
I	3.048	3.058		3.055	3.055	3.055	3.055		
J	4.575	4.585		4.578	4.578	4.578	4.578		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.502	.501	.501		
N	1.615	1.635		1.633	1.633	1.633	1.633		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.259	2.259	2.259	2.259		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.006	2.006	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Onk /85	Audited by:	JL
Date:	08/08/04	Date:	08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	DA

DART AEROSPACE LTD		Work Order: <i>29793</i>
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.440	.446				
B	1.745	1.755		1.750	1.756				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.256				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.322	.322				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.055	3.054				
J	4.575	4.585		4.579	4.579				
K	0.315	0.322		.322	.322				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.501	.501				
N	1.615	1.635		1.630	1.636				
O	7.990	8.010		8.000	8.006				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.316				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.515	.520				
T	1.375	1.395		1.380	1.386				
U	2.000	2.020		2.000	2.000				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Om</i>	Audited by:	<i>J</i>
Date:	08/08/26	Date:	08.08.26

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>JK</i>

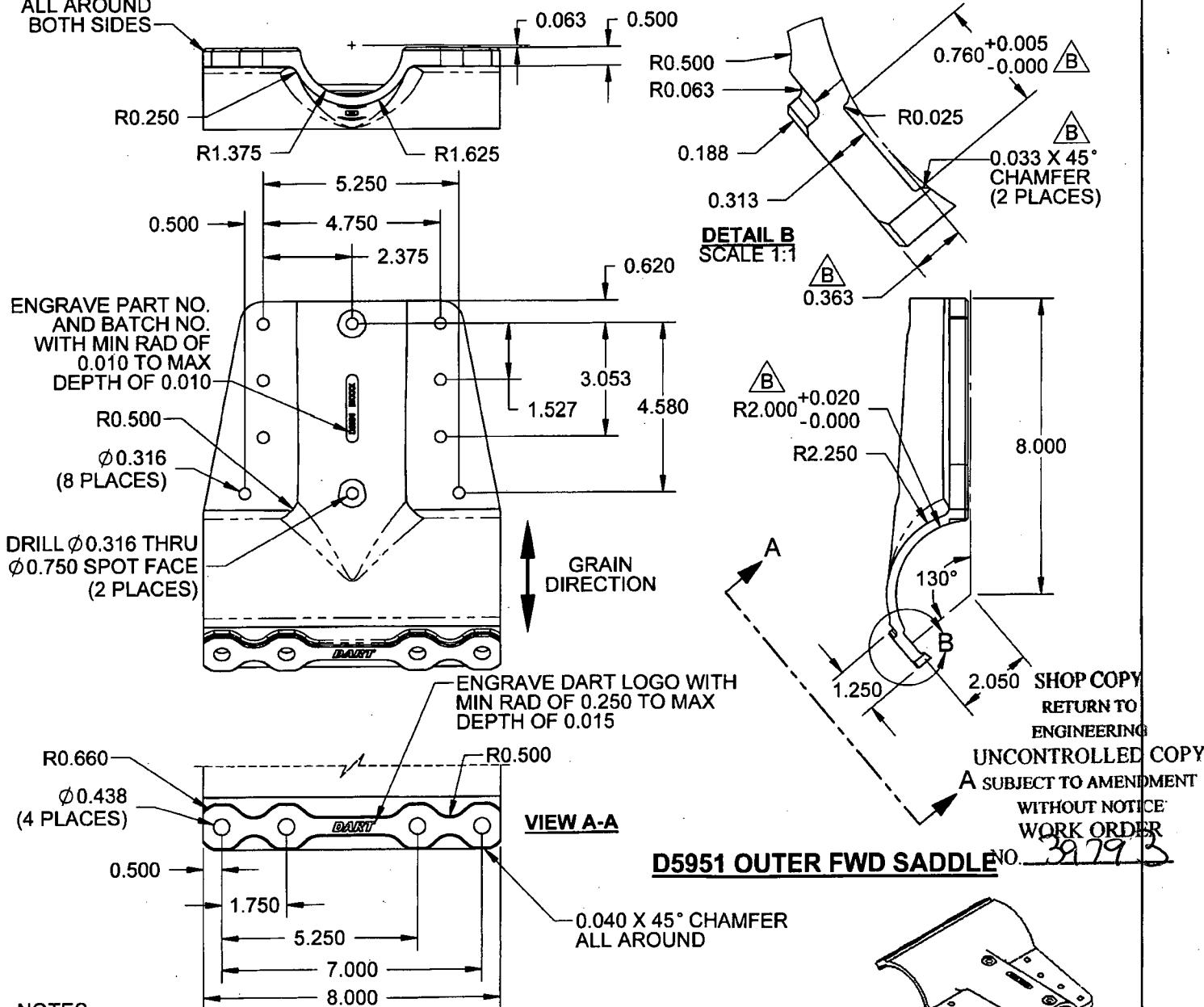


DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D5951	REV. B	SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE	SCALE 1:4		
REV	DATE	DESCRIPTION		
A	97.05.06	NEW ISSUE		
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;		

CHAMFER
0.075 X 45°

96.11.2

**CHAMFER
0.075 X 45°
ALL AROUND
BOTH SIDES**



NOTES:

- NOTES:**

1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

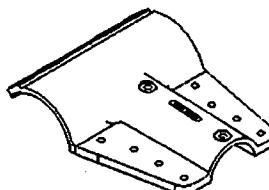
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.010 TO 0.020

B

ISOMETRIC VIEW
SCALE 1:8



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